

Date: Thursday, 4/20/2006 1:31:54 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUBBLE WINDOW, RH
Job Number	: 26749		
Estimate Number	: 11394		
P.O. Number	: N/A	Part Number	: D32692
This Issue	: 4/20/2006 S.O. No. : N/A	Drawing Number	: UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 26192	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 4/26/2006 Qty: 5 Um: Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est. A05.03.22 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 1046

Manufacture D3269-2 as per Dwg D3269

Possible Supplier: Canus

Material release note is required

u 060420

2.0	D32692P	Bubble Window, RH R44
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
 Bubble Window, RH R44

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

AP 06/04/24 5

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

876  
 06-04-25 (5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: /

C 06/04/25 (5)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-04-25	4.1	Engrave Part: batch # on window as per Dwg.	<i>[Signature]</i>	06-04-25	5	<i>[Signature]</i>	<i>[Signature]</i>
	4.2	Inspect work QCS	<i>[Signature]</i>	06-04-25	5		
	4.3	Wrap windows inside and out with Plastic film.	<i>[Signature]</i>	06-04-26	5		
		Add to estimate. permanent change.					

*See next page.*

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/04/26

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUBBLE WINDOW, RH

Job Number: 26749

Part Number: D32692

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/04/26 (5)

Job Completion



CL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.04.26	6	See Attached E-mail				UP 06.04.26 Per 06.04.26	2 06.04.26

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**JS PLASTICS INC.**

**300 Lisgar Street**

**Ottawa, ON**

**K2P 0E2**

Phone: 613 232 2657

Fax: 613 232 6214

info@canusplastics.com

www.canusplastics.com

**Packing Slip** 125090

**CUSTOMER NO. 163233**

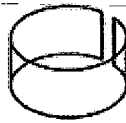
**BILL TO:** DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

**SHIP TO:** SAME

Attn: Accounts Payable

(613)632-3336

DATE	SHIP VIA	F.O.B.	TERMS
04/24/06	Pick up	Our Dock	Net 30 days
P.O. NUMBER	ORDER DATE	SALESPERSON	
PO00001046	04/24/06	TM	
PART NUMBER	DESCRIPTION	REQ.	QUANTITY SHIPPED B.O.
MFG	D32692P,BUBBLE WINDOW RH R44	5	5



**CANUS** Plastics Inc.

300 LISGAR ST  
OTTAWA, ONTARIO  
K2P 0E2  
PH: 613-232-2657  
FAX: 613-232-6214

Certificate of Conformance

Date: 12/09/05

To: DART AEROSPACE  
1270 ABERDEEN ST.  
HAWKESBUURY, ON  
K6A 1K7

P.O.#: PO00001046  
Order# 125090

The undersigned hereby certifies that the materials supplied and the items shipped under the above purchase order, are in conformance with, all applicable specifications and/or purchase order requirements. All reports of the materials supplied are on file and can be made available upon request.

<u>Quantity</u>	<u>Description</u>	<u>Specification</u>
5	D32692P BUBBLE WINDOW	PER DWG# D3269 REV B

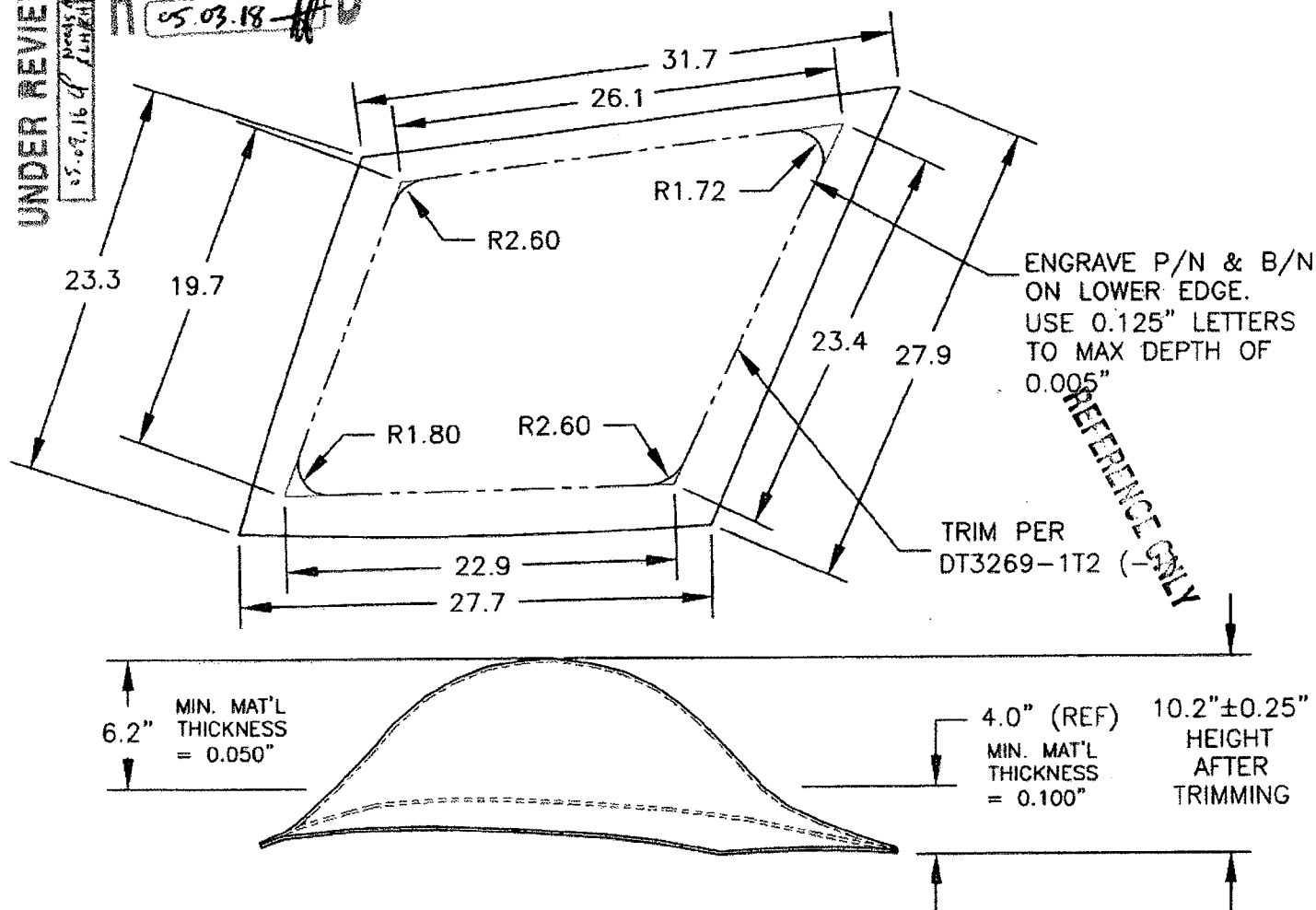
SIGNED: \_\_\_\_\_



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3269
				REV. B SHEET 1 OF 1
DATE	05.03.10	TITLE	BUBBLE WINDOW (R44)	SCALE 1:10
A	05.02.18	NEW ISSUE		
B	05.03.10	UPDATE MATERIAL SPEC.		

UNDER REVIEW  
05.07.16 *[Signature]*  
05.03.18 *[Signature]*

RELEASED  
05.03.18 *[Signature]*



**D3269-1 BUBBLE WINDOW, LH (SHOWN)/ D3269-2 BUBBLE WINDOW, RH (OPPOSITE)**

- 1) FORM PER D3269-1T1 (-1) OR D3269-2T1 (-2)  
FORMING PROCESS:
  - (a) DRAPE OVER D3269-1T1/-2T1 MOLD
  - (b) HEAT TO 250°F
  - (c) VACUUM FORM TO SPECIFIED HEIGHT
  - (d) LEAVE FOR AT LEAST 20 MINUTES COVERED WITH INSULATED BLANKETS TO COOL
- 2) TRIM PER TEMPLATE D3269-1T2 (-1) OR D3269-2T2 (-2)
- 3) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.188 TH. MINIMUM THICKNESS AFTER FORMING AS SHOWN ABOVE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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## Jason Murdoch

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** April 26, 2006 11:12 AM  
**To:** Chris Provencal  
**Cc:** Linda Lacelle; Jason Murdoch; Bill Beckett  
**Subject:** Re: bubble window install mod

Chris,

It is acceptable to ship the windows in an untrimmed configuration. The windows should meet all other criteria specified on the drawing. Dart Engineering will provide the customer with instructions for trimming the windows to ensure that they are installed safely. Please attach a copy of this email to the applicable work order.

David

----- Original Message -----

**From:** "Chris Provencal" <cprovencal@dartaero.com>  
**To:** <davids@dartaero.com>  
**Sent:** Tuesday, April 25, 2006 1:09 PM  
**Subject:** bubble window install mod

> David,  
>  
> They want to ship out some D3269-2 bubble windows whose flanges have \*not\*  
> been trimmed per the dwg. I am creating a DSI with instructions to trim  
> the  
> window. The windows will have to be recorded as a "work order change".  
> Is  
> this change acceptable?  
>  
> Sincerely,  
> Chris Provencal  
> DART Aerospace Ltd.  
> Email..cprovencal@dartaero.com  
> Phone....613-632-3336  
> Fax.....613-632-4443  
>  
>



## Linda Lacelle

---

**From:** David Shepherd [davids@dartaero.com]  
**Sent:** Wednesday, April 26, 2006 12:28 PM  
**To:** Linda Lacelle; 'Chris Provencal'  
**Cc:** 'Jason Murdoch'; 'Bill Beckett'; \*Sue Bedford (E-mail); Brigitte Golden (E-mail)  
**Subject:** Re: bubble window install mod

Linda,

It is my understanding that we are shipping the parts to the customer and that we will follow up with the DSI by email. If I am wrong, then I assume one of the recipients of this email will correct me.

David

----- Original Message -----

From: "Linda Lacelle" <llacelle@dartaero.com>  
To: "'David Shepherd'" <davids@dartaero.com>; "'Chris Provencal'" <cprovencal@dartaero.com>  
Cc: "'Jason Murdoch'" <jmurdoch@dartaero.com>; "'Bill Beckett'" <bbeckett@dartaero.com>; "\*Sue Bedford (E-mail)" <sueb@dartaero.com>; "Brigitte Golden (E-mail)" <brigitteg@dartaero.com>  
Sent: Wednesday, April 26, 2006 10:01 AM  
Subject: RE: bubble window install mod

> Is there a DSI to go with these windows? Is it ready ..  
> Brig/Sue, have you rec'd the P.O to ship these?

> -----Original Message-----

> From: David Shepherd [mailto:davids@dartaero.com]  
> Sent: Wednesday, April 26, 2006 11:12 AM  
> To: Chris Provencal  
> Cc: Linda Lacelle; Jason Murdoch; Bill Beckett  
> Subject: Re: bubble window install mod

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> David

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> Subject: bubble window install mod

> > David,

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> Is  
> > this change acceptable?  
> >  
> > Sincerely,  
> > Chris Provencal  
-----> > DART Aerospace Ltd.  
> > Email...cprovencal@dartaero.com  
> > Phone...613-632-3336  
> > Fax.....613-632-4443  
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